

5/24

5

DART AEROSPACE LTD	Work Order:	23424
Description: Strut	Part Number:	D2749-3
Drawing: D2749 Rev. B	Qty:	15

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	JF	05.05.26	15
2	METAL	Cut blank: 8.75" long Material: $\frac{3}{4}$ " x $\frac{3}{4}$ " bar 6061-T6	MJF-790 Batch: 15735 10346	05.06.01	15
3	HAAS	Machine as per folio D2749-3	JL	05/06/19	15
4	QC	Inspect Level 2	JL	05/06/19	15
5	QC	Inspect Level 8	JL	05.06.19	15
6	METAL	Tumble and Deburr	JL	05/06/19	15
7	METAL	Acid etch and Alodine as per QSI 005 4.1	M	05.06.20	15
8	QC	Inspect Level 7	J	05.06.21	15
9	FINISHING	Powder Coat gloss white (4.3.5.1) per QSI 005 4.3	JL	05/06/21	15
10	QC	Inspect Level 3	M	05.06.21	15
11	STORES	Identify and stock	DL	05/06/23	15
12	EXPEDITING	Close W/O Cost / part: 8.72 \$45 05/06/24 (15)	JF	05.06.28	15

Rev	Date	Change	Revised By	Approved
A	99.09.29	Preliminary Issue	EC	
B	99.11.22	Re-format, released	EC	
C	00.05.19	Added inspection level 8, removed P/O for powder coating	EC	

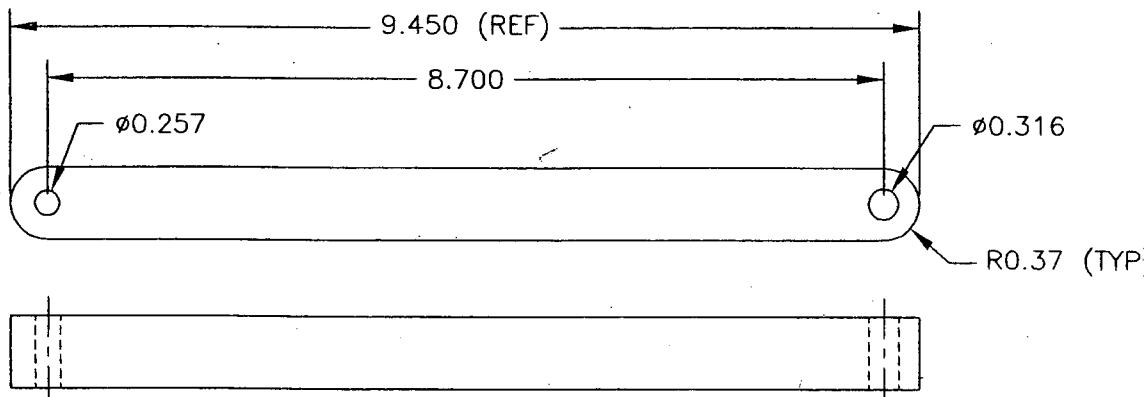
RELEASED

EC 00.05.24

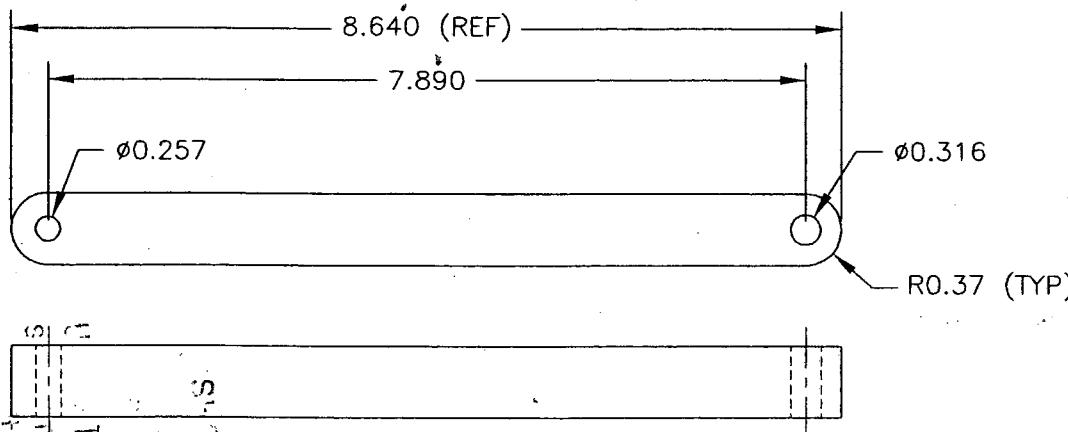
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



2749-1 STRUT



2749-3 STRUT

SUPPLY COPY
 TURN TO
 DRAWING
 DRAFTING
 COPIER
 REPRODUCTION
 NOTICE

MATERIAL: 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8) 0.75 X 0.75 BAR
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3

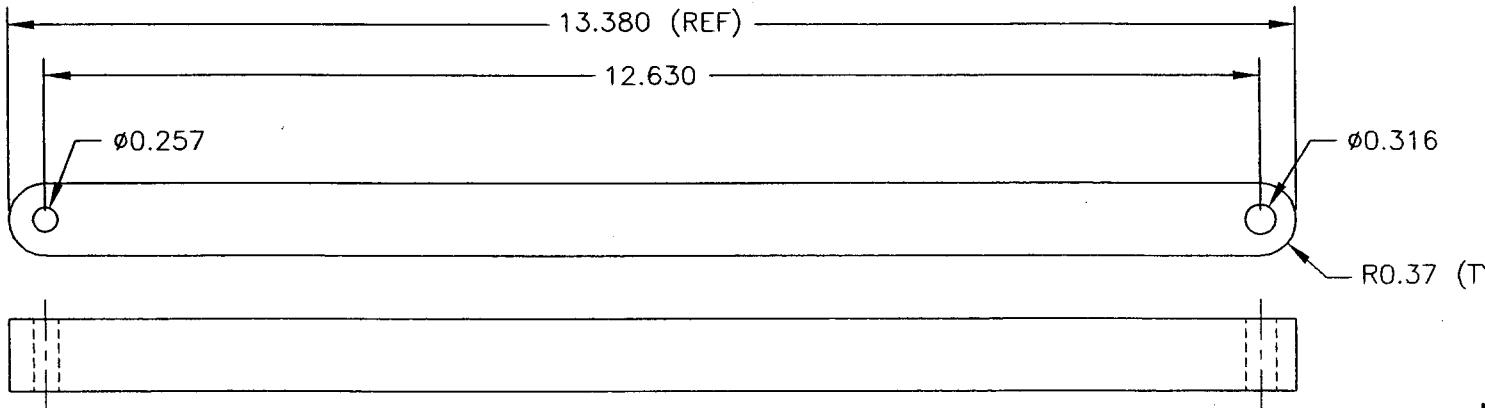
RELEASED
99.10.12
KE

DART
AEROSPACE LTD

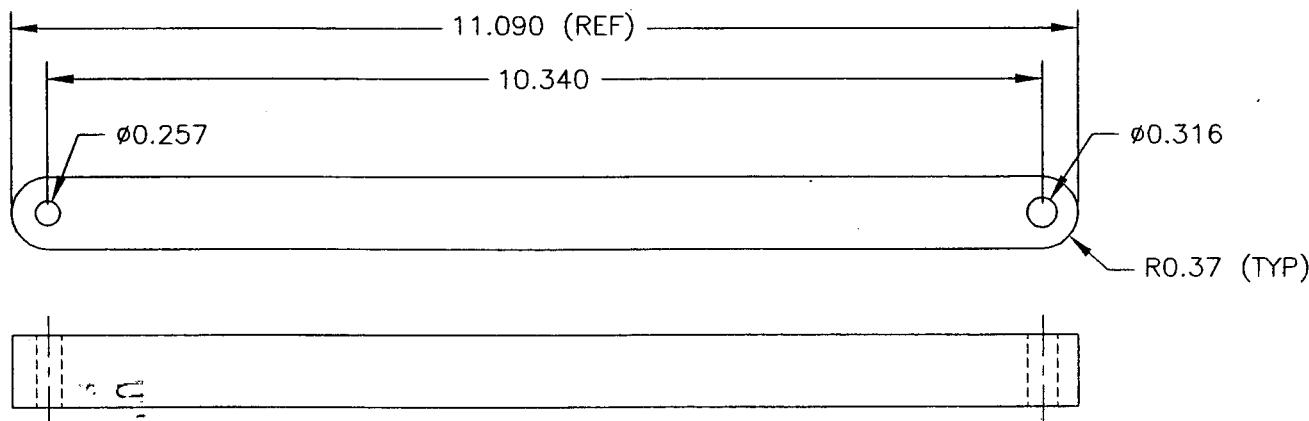
COPY GEN
SHEET 1 OF 2

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
/	JL	D2749
DATE		SCALE
99.10.08	A	99.09.24 NEW ISSUE
99.10.08	B	99.10.08 REMOVED LIGHTENING HOLES
		1:2

WORK ORDER
NO. Z3424



2749-5 STRUT



2749-7 STRUT

SHOF COPY
RETURN TO
ENGINEERING
RELEASER
SHEET 1 OF 1
MATERIAL: 6061-T6 (QQ-A-225/8) OR 6061-T6 (QQ-A-200/8) 0.75 X 0.75 BAR
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3

RELEASED
99.10.08 KE

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2749
DATE 99.10.08	TITLE STRUT	SHEET 2 OF 2 SCALE 1:2

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 25, 2005
03:44 pm

Work Order No	:	0023424	Department Code:	
Project Name	:	D2749-3	Burden Flags	: NNNNNNN
Project For	:	WK524	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2749-3	Invoice Number	:
Description	:	Strut	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	15	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	05-24-05	Est Mark Up	: 0.000%
Est Finish Date	:	06-23-05	Actual Mark Up	: 0.000%
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00

DART AEROSPACE LTD

Work Order: 23424

Description strut

Part Number: A2749-3

Inspection Date: A2749

Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

Prototype

Wegener's syndrome

JL

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05/06/19

Audited by:

1

Date:

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	